

Work Order ID 158834

Friday, March 31, 2017 10:17:03 PM

158834**U/R**

OK 07/17/13

Page 1

Item ID: D3594-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Doubler
Start Date: 4/3/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 4/6/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: DAS Date: APR 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3594	C

100 FLOW WATER JET 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3594

Dwg Rev: CProg Rev: C

2-Deburr if necessary

0.00

6002/17/04/04

110 QC2- Inspect parts off machine FAI/FAIB 0.00

110

QC

Quality Control

Memo

0.06

6002/17/04/04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Friday, March 31, 2017 10:17:03 PM

158834

Item ID: D3594-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Doubler

Stop *NS2*

Start Date: 4/3/2017 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 4/6/2017 **Req'd Qty:** 6.00

6

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.12

Quality Control

DAS
38
9-89
APR 05 2017

130

0.00

130

Small Fab

Small Fab

Memo

0.13

Small Fab

1-C'SINK AS PER dwg d3594

6x _____ 17/04/06

140

0.00

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.12

Quality Control

DAS
38
9-89
APR 06 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

158834

Friday, March 31, 2017 10:17:03 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/3/2017 **Start Qty:** 6.00 ***6***

Required Date: 4/6/2017 **Req'd Qty:** 6.00 ***6***

Customer:

Reference: SCHEDULED

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Chemical Conversion Coat per QSI005 4.1

0.00

150

Memo

0.27

HandFinish

Hand Finishing

QC3- Inspect Part Finish

0.00

160

Memo

0.06

QC

Quality Control

Identify as per dwg & Stock Location: ST041

0.00

170

Memo

0.06

Packaging

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Page 4

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Item ID: D3594-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 4/3/2017 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 4/6/2017 **Req'd Qty:** 6.00 ***6***

Customer:

Reference: SCHEDULED

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.60

Quality Control

DAS
21
9-89

APR 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																												
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Picklist Print

Friday, March 31, 2017 10:17:02 PM

Page 1

Work Order ID: 158834

158834

Parent Item: D3594-5

D3594-5

Parent Item Name: Doubler

Start Date: 4/3/2017

Required Date: 4/6/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 08.07.07 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	119.6500	0.055	0.347368			

M6061T6S 080

6061-T6 .080 Sheet

02/17/07/04

Location

Loc Qty

Loc Code

MAT020

119.65

m135861

10.5

m136342

73.85

m136632

9.3

m137110

26

.4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

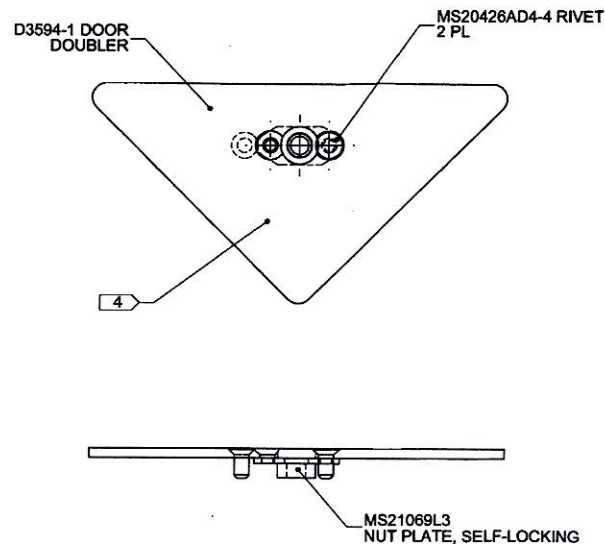
QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
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Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

ITEM	QTY	P/N	DESCRIPTION
	X	D3594-041	DOUBLER ASSEMBLY
1	1	D3594-1	DOUBLER
2	1	MS21069L3	NUT PLATE, SELF-LOCKING
3	2	MS20426AD4-4	RIVET, SOLID, CSK



D3594-041 DOOR DOUBLER ASSEMBLY

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 7) WEIGHT: 0.04 lbs

UNDER REVIEW

URF16-673 CP

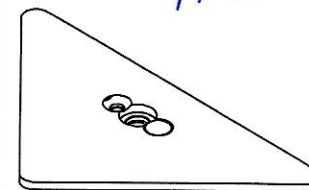
16-11-16

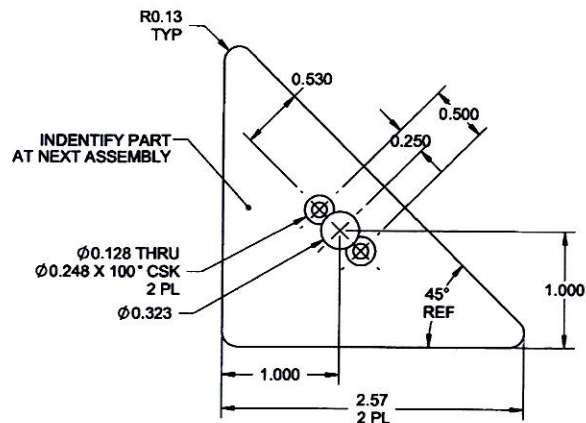
RELEASED
 2016-07-26
 ECN 16-531

APPROVED

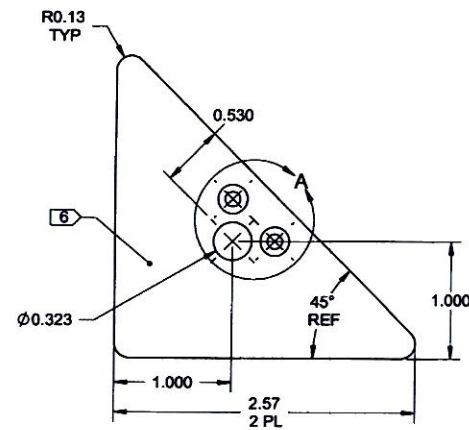
C	REFORMAT TO CURRENT STANDARDS. ADD 0.5" OF MATERIAL TO -3 & -4 REASON PAR18-S01.	AJS	16.05.25
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -S.	AJS	08.05.14
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
DATE	16.05.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 158834 MLS
 1704-09

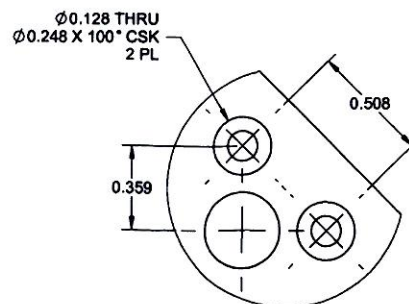




D3594-1 DOOR DOUBLER



D3594-5 DOOR DOUBLER



**DETAIL A
SCALE 2X**

UNDER REVIEW

URF16-673 CP
16-11-16

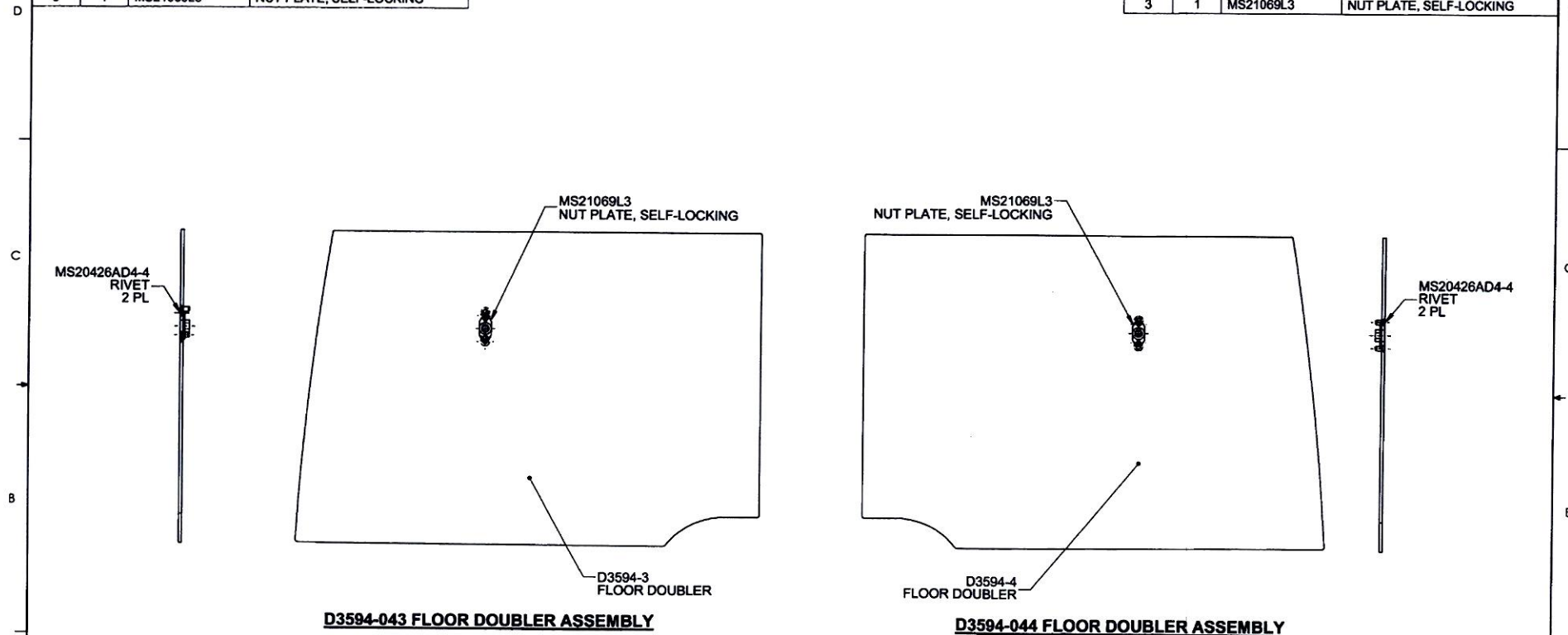
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION -5 ONLY: IDENTIFY PER DART QSI 044
 - 7) WEIGHT -1/-5: 0.03 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 2 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DSE	DOUBLER	NTS
DATE	16.05.25	COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-07-26

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3594-043	FLOOR DOUBLER ASSEMBLY
1	1	D3594-3	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069L3	NUT PLATE, SELF-LOCKING

ITEM	QTY -044	P/N	DESCRIPTION
	X	D3594-044	FLOOR DOUBLER ASSEMBLY
1	1	D3594-4	DOOR DOUBLER ASSEMBLY
2	2	MS20426AD4-4	RIVET, SOLID, CSK
3	1	MS21069L3	NUT PLATE, SELF-LOCKING



UNDER REVIEW

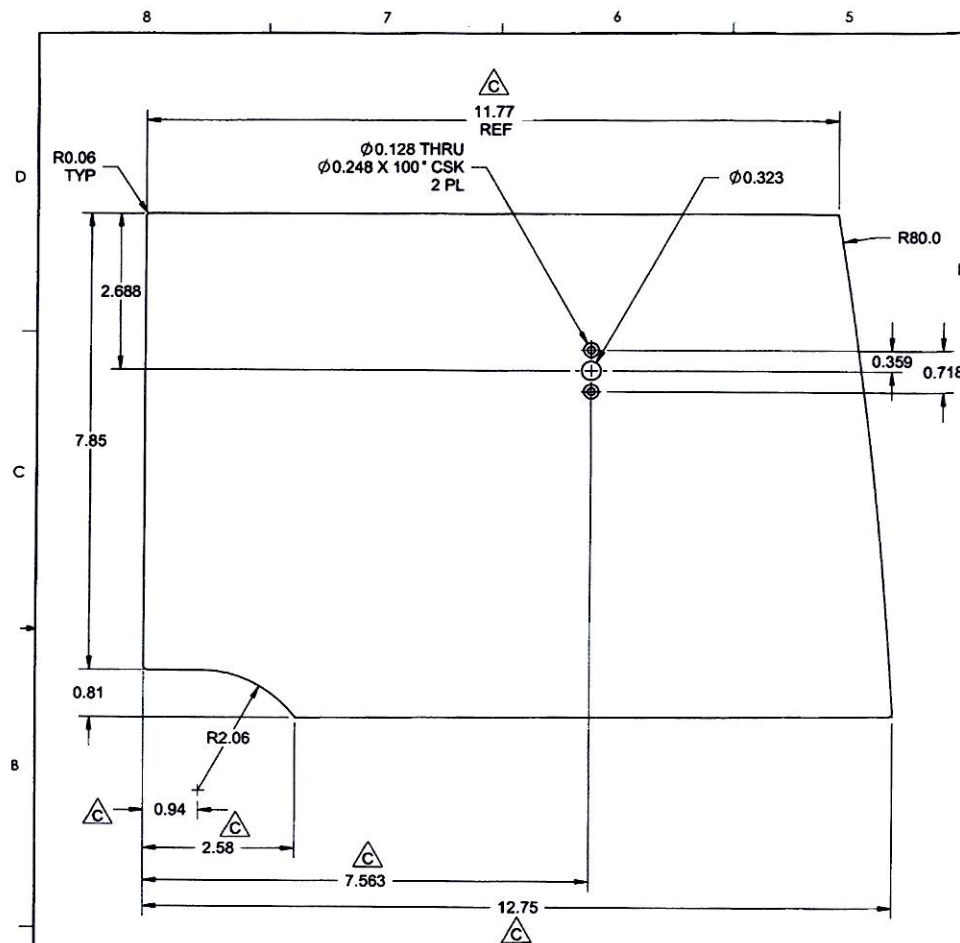
URF16-673 CP
16-11-16

NOTES:
1) MATERIAL: NONE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER DART QSI 044
7) WEIGHT: 0.82 lbs

RELEASED
2016-07-26

APPROVED

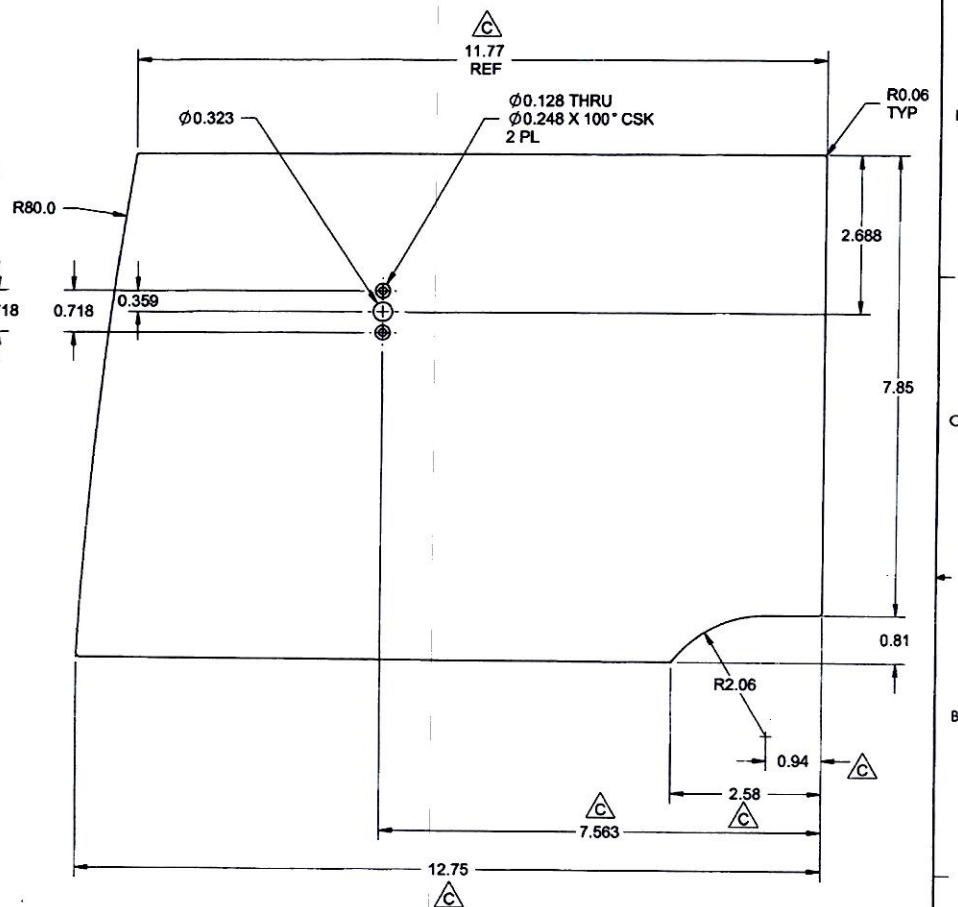
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. C
MFG. APPR.	DD	D3594	SHEET 3 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	DOUBLER	NTS
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D3594-3 FLOOR DOUBLER

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 REF. DART SPEC. M6061T6S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: 0.82 lbs



UNDER REVIEW D3594-4 FLOOR DOUBLER

URF16-673 CP

16-11-16

RELEASED
2016-07-26

APPROVED

DESIGN	MB
DRAWN	AJS
CHECKED	MB
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	16.05.25

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3594** REV. C
SHEET 4 OF 4
TITLE **DOUBLER** SCALE NTS

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